

Date: Monday, 22/01/2007 1:53:39 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206 L/L 1/L3 SCUFF PLATE, FWD RH	
<b>Job Number</b> :	30365	<b>Part Number</b> :	D206555006	
<b>Estimate Number</b> :	12269	<b>Drawing Number</b> :	D206-555 REV C	
<b>P.O. Number</b> :	N/A	<b>Project Number</b> :	N/A	
<b>This Issue</b> :	22/01/2007	<b>S.O. No.</b> :	N/A	
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	C	
<b>First Issue</b> :	N/A	<b>Material</b> :	SIA	
<b>Previous Run</b> :	30365	<b>Due Date</b> :	29/01/2007	<b>Qty:</b> 12 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :				
<b>Comment</b> :	Est C 99.06.29 Returned to Electro Polish DM Est Rev:D Now On Waterjet 07-01-22 JLM			



**Additional Product** :

**Job Number:** 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
		

**Comment:** DOCUMENT CONTROL  
Type Labels as per PPP D206-555-006



2.0	M304S25GA	304/316 .020" Sheet
		

**Comment:** Qty.: 0.4610 sf(s)/Unit Total : 5.5320 sf(s)  
304/316 .020" Sheet

Batch: m102393

ml 07 01 23

(12)

3.0	WATER JET	FLOW WATER JET
		

**Comment:** FLOW WATER JET  
1-Cut as per Dwg D206-555

Dwg Rev: C

Prog Rev: C



ml 07 01 23

(12)

2-Deburr if necessary

mf. 07-01-23



(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 01 23

(12)

5.0	QC8	SECOND CHECK
		

**Comment:** SECOND CHECK

07/01/23 (12)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD RH

Job Number: 30365

Part Number: D206555006

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8318-6

Finish form on bench forming Jig DT 8319-6

SB 07/01/24 12

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/24 (2)

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 2930

Possible supplier: TQF Technologies

07/01/24 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

07/01/24 07/01/22 (12)

10.0

QC6

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-01-30

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

SB 07/01/30 12

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD RH

Job Number: 30365

Part Number: D206555006

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*U 07-01-30*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*E 04/01/30 (12) P 7/01/30 (12)*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(12) 07-01-30*

Job Completion



*U 07-01-30*

**DART**

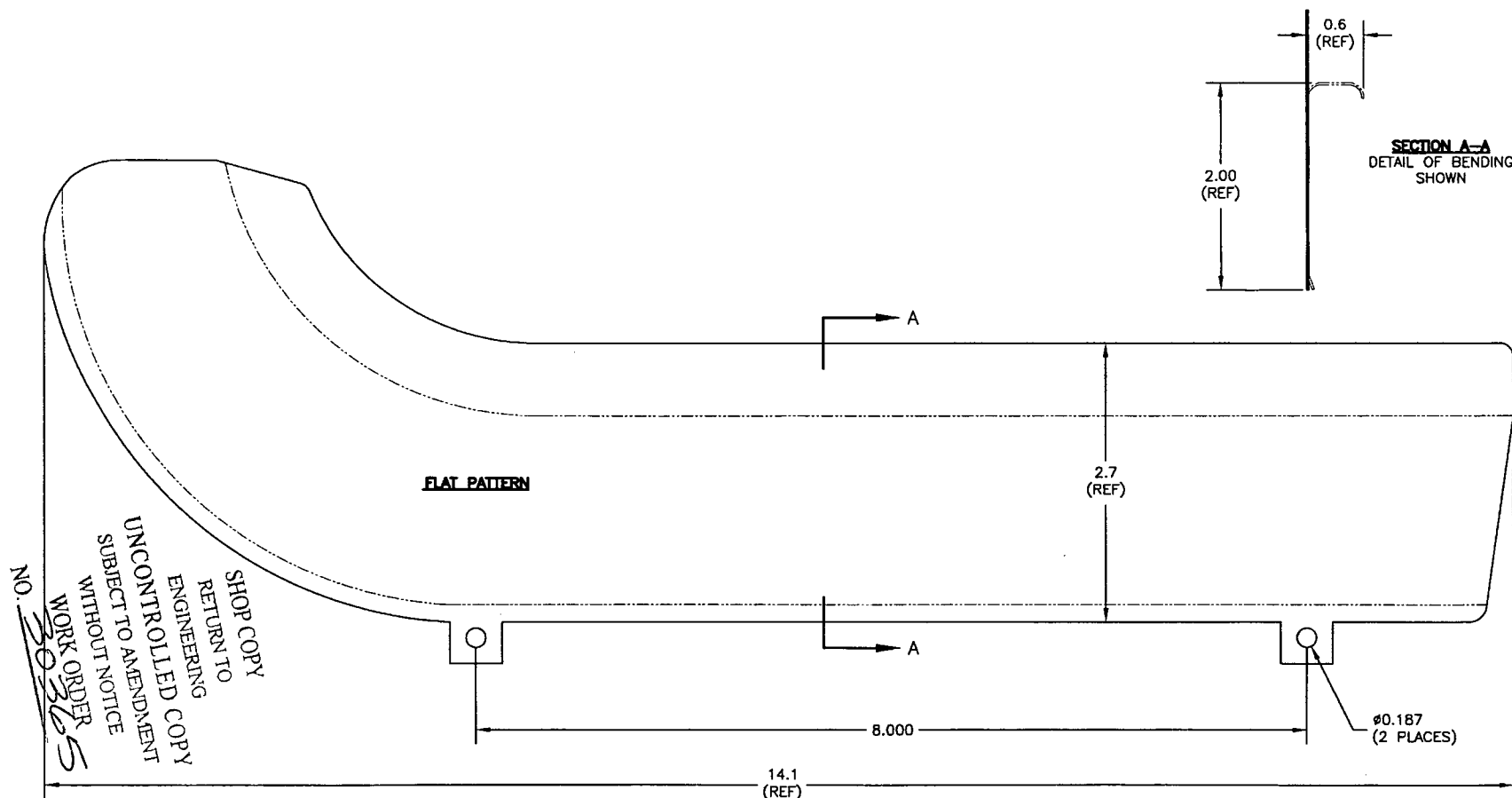
DESIGN JB	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30365

**RELEASED**06.09.19 *[Signature]***Copyright © 1989 by DART AEROSPACE LTD**

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D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)  
D206-555-002 (BEND OPPOSITE)

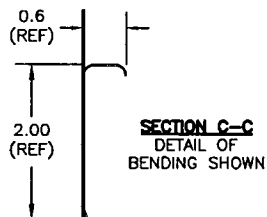
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.14

DESIGN JB	DRAWN BY B	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D206-555	REV. C SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES		SCALE 1:1



**DETAIL B**  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

16.000 (REF)

2.7  
(REF)

**FLAT PATTERN**

8.000

19.0  
(REF)

8.000

Ø0.187  
(3 PLACES)

**RELEASED**

06.09.19-#

**D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)**

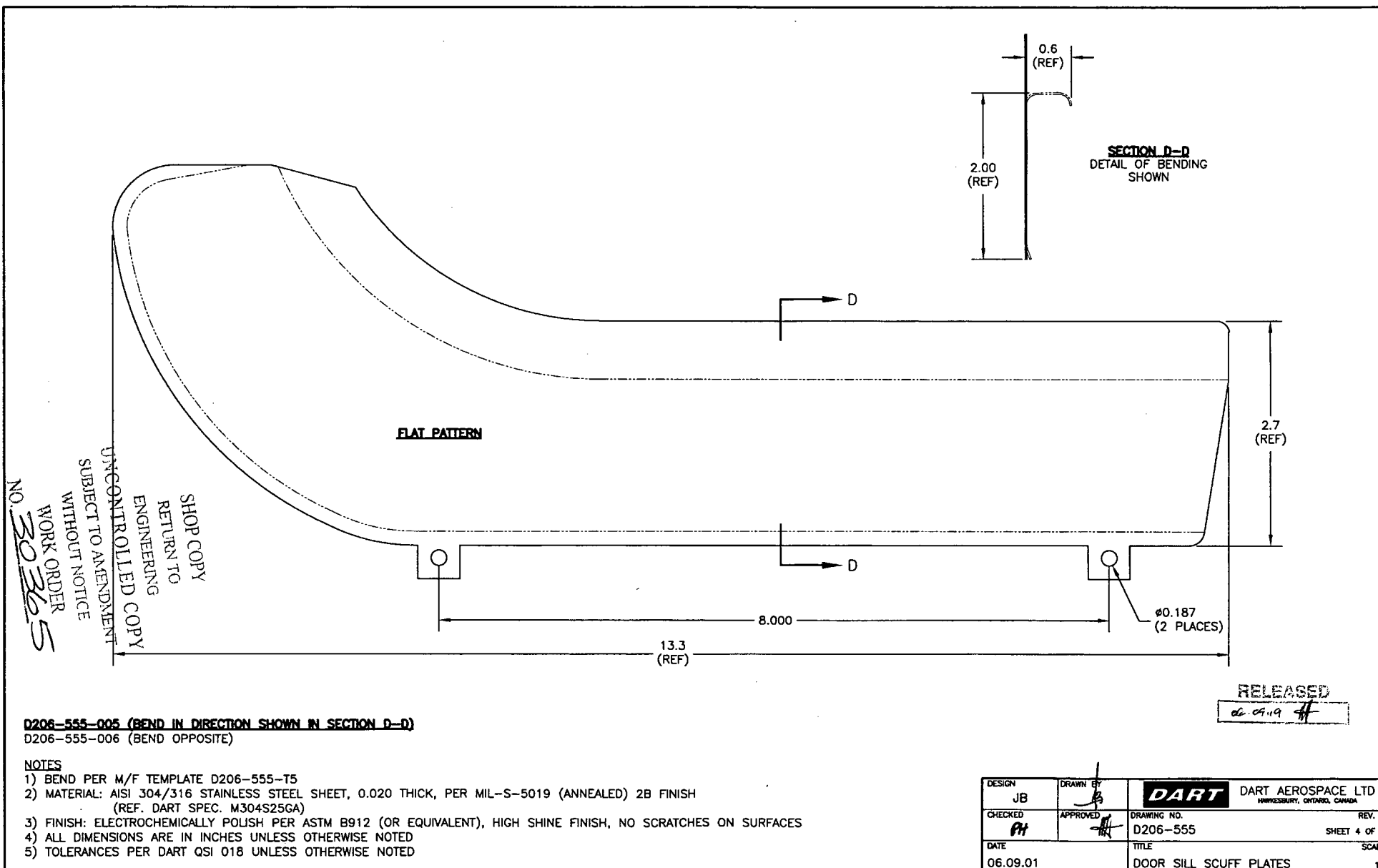
**D206-555-004 (BEND OPPOSITE)**

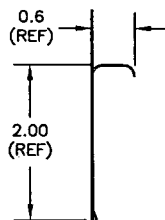
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

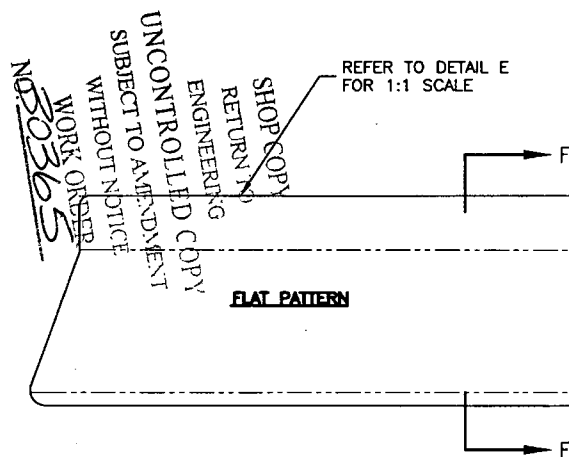
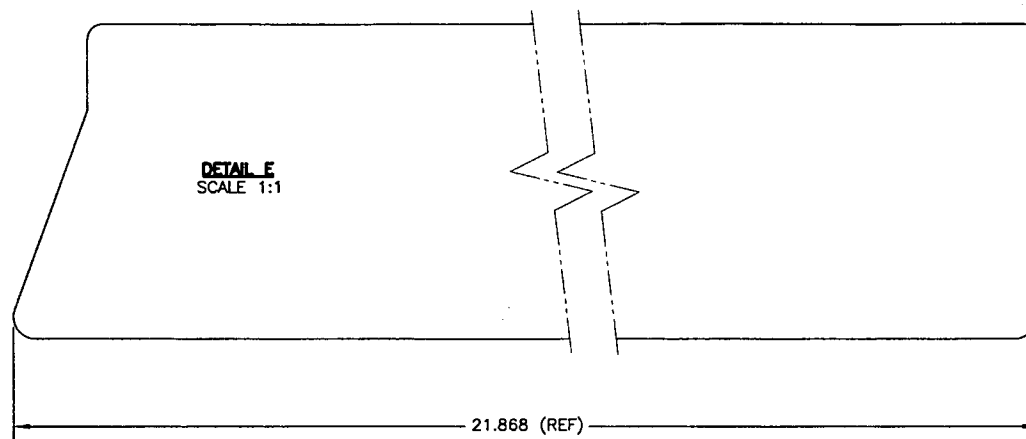
DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WINNIPEG, MANITOBA, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	

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**SECTION F-F**  
DETAIL OF  
BENDING SHOWN



2.7  
(REF)

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06.09.19

**D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)**

**NOTES**

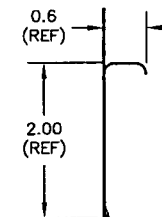
- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



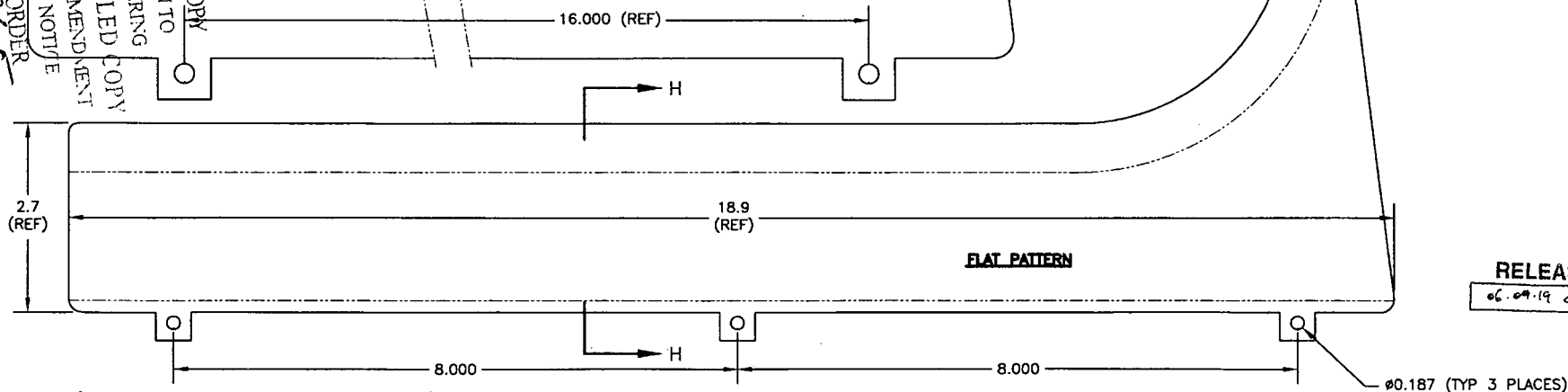
WORK ORDER  
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DETAIL G  
SCALE 1:1



SECTION H-H  
DETAIL OF  
BENDING SHOWN

REFER TO DETAIL G  
FOR 1:1 SCALE

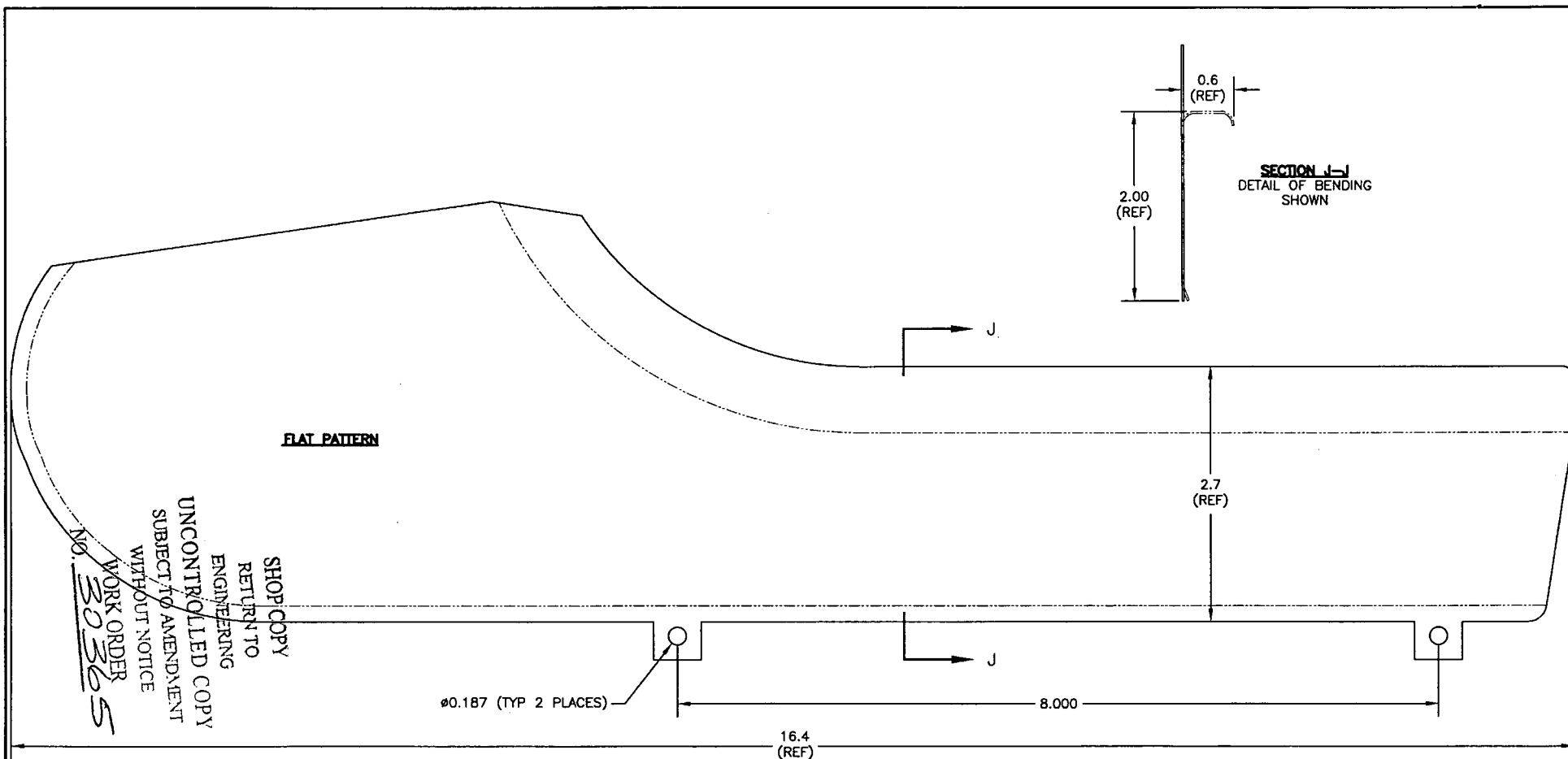


D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

# NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)  
D206-555-012 (BEND OPPOSITE)

#### NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.01

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WILKESBORO, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 7 OF 7 SCALE 1:1





## Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: January 26, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat  
Certification No.

K6A 1K7

tel.: (613) 632-9577

fax: (613) 632-1053


**C112101**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
123010	✓ 10	NO. DE COM./P.O.# 2930 D206-555-005 B30364	ELECTROPOLISH PER ASTM B912 REV.02  U 07-01-30
	✓ 12	D206-555-006 B30365	

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

Signé pour et au nom de TQF Technologies Inc.  
Signed for and on behalf of TQF Technologies Inc.

Raj Thakoordeen

## CUSTOMER RETURN

Initiator: Jean Kerr  
 Company: Alpine Aerotech Ltd  
CALP102  
 Phone No: 250-769-6344

Date: March 11/00  
 Invoice # 3957  
 Order Entry # 3421

Attach Copy of DHS Return Authorization # 379

Reason for return: Plates not fitting. Wishes A replace - product on hold  
AS per Peggy.

Receiving: 8/3/13 Freight Company: FISHP Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
1	D206-555-005	31184	Scuff Plate End Lt	Advise QA	Date:
1	D206-555-006	30365	Scuff Plate End R/L	<u>DAV</u>	<u>8/3/14</u>

Condition of packaging: 6W2 Photograph required: yes no

Paperwork attached: P/S P Invoice   ARC   Docs   Other  

## QC:

Quarantine: Location:   Condition of Part: good/in bag

Inspect: Initial: chgo02

#	Part #	Batch #	QC Comments	QC Approval		Scrap
1	D206-555-005	B31184	Place under quarantine as	Initial	W/O #	
1	D206-555-006	B30365	per w/o	<u>[Signature]</u>	<u>38075</u>	
					<u>38076</u>	

## QA Coordinator:

Advise GM as to findings: Initial:   Date:  

Comments:

Issue credit: <u>yes</u> <u>no</u>	Invoice Amount: <u> </u>
GM Approval: <u> </u>	Less Replacement: <u> </u>
Date: <u> </u>	Restock Fee: <u> </u>
	Freight: <u> </u>
	Net Credit: <u> </u>
	DHS <input type="checkbox"/> Customer <input type="checkbox"/>

QA: Enter into Q-Pulse with reason for return & File original. Signed:   Date:  

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit